

Date: Monday, 6/5/2006 11:01:41 AM
 User: Kim Johnston

Process-Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 27417	
Estimate Number : 10271	
P.O. Number : N/A	Part Number : D2561
This Issue : 6/5/2006 S.O. No. : N/A	Drawing Number : D2561 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25968	Material : N/A
Written By : <i>See comment below</i>	Due Date : 6/26/2006
Checked & Approved By : <i>06-06-05</i>	Qty: 30 Um: Each
Comment : Est C 00.05.19 Added inspect level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
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Comment: Qty.: 0.3850 f(s)/Unit Total : 11.5511 f(s)
 Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick
 Batch: *1100782* *mi7869*
12 ft *2 ft*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 1-Cut blanks: 8.70"
 Note: 1 blank makes 2 parts

3.0	HAAS4 Water jet	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per folio D2561
 2-Deburr, no sharp edges

Prog. Rev. *B*
 Dwg Rev. *B*

06 06 07 (30)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06 06 07 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27417

Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



26-06-08

(30)

Comment: SECOND CHECK

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr , no sharp edges

SAD 06/06/11

30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5049*

26/6/12 30

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

19 06/06/13

(30)

Job Completion



U 26-06-13

*Please
drill .257
holes. before
deburring*

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

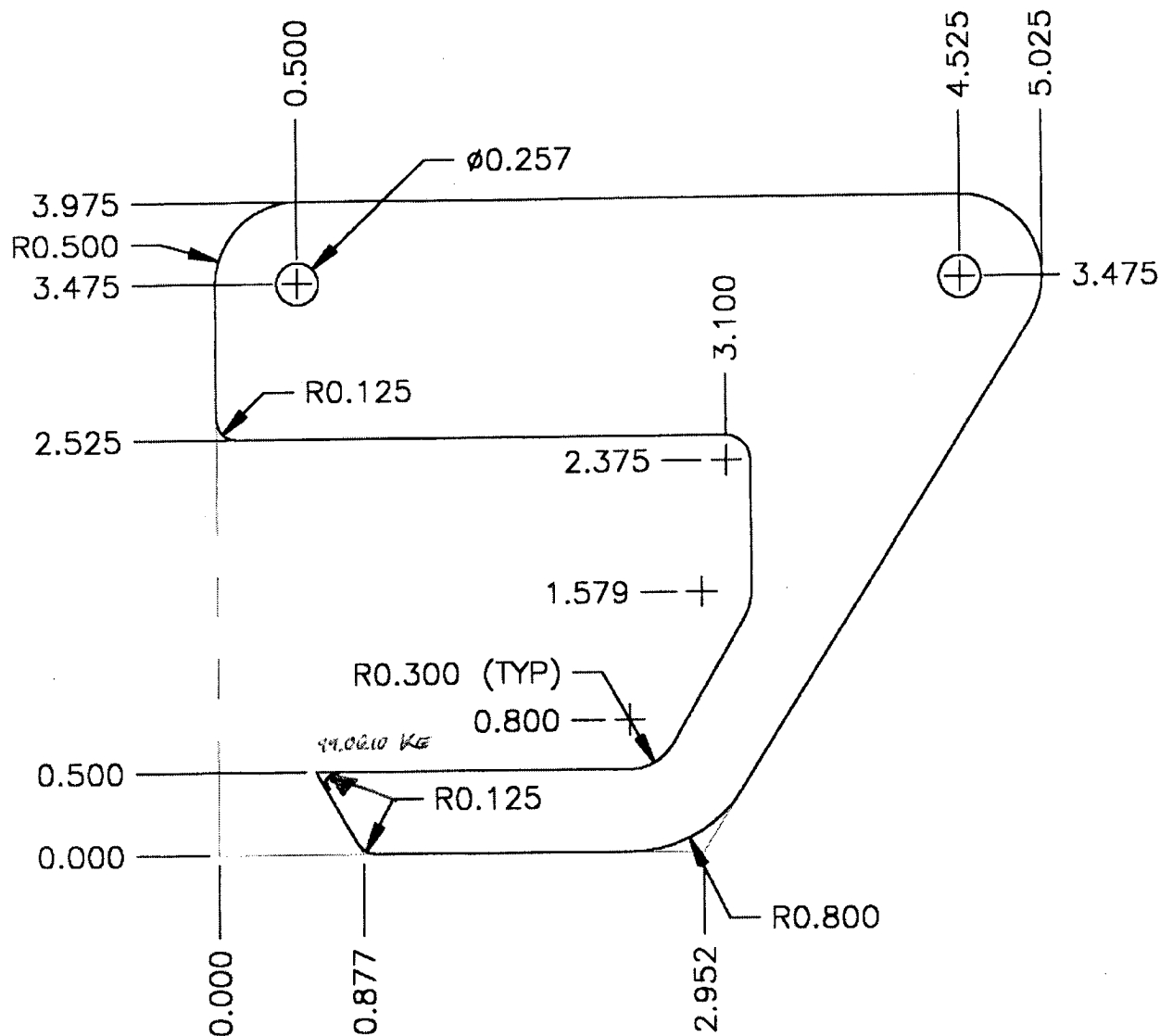
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>BW</i>	<i>BW</i>	D2561	SHEET 1 OF 1
DATE	TITLE		SCALE
96.04.26	LUG PLATE		1:1

RELEASED
96 05 06



MATERIAL: 6061-T6 0.25 THICK
OR 6063-T6 0.25 THICK
OR 5052-H34 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

WORK ORDER
NO. 27417